
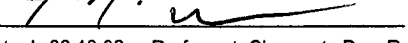



Date: Tuesday, 1/2/2007 1:27:46 PM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 30095	
Estimate Number : 10531	
P.O. Number : N/A	Part Number : D2572
This Issue : 1/2/2007 S.O. No. : N/A	Drawing Number : D2572 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 29661	Material : N/A
Written By : 	Due Date : 1/9/2007
Checked & Approved By : 	Qty:  Um: Each
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

Additional Product

Job Number: .



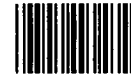
Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2572
 Ensure that grain is along 5.00" length
 Batch No: B25352 x 12 Ep 07/01/02

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. B30025 Double check by: J.F.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove shap edges.

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
07/01/06	30	1 (core) part affected. Keyway cut to width at far left skid tube hole 0.777" instead of 0.765" only that area affected. Rest of the keyway is 0.765"	J 05/04/06	Part was fitted onto a skid tube. Part acceptable	CP 07/01/06	07/01/06	J 05/04/06	J 06/01/06
		moved in the wrong direction during set up.						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/01/06

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 1/2/2007 1:27:46 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 30095

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JS/Er 07/01/09 (12)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/01/10 (12)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JR 07/01/10 x12

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL/JR 07/01/11 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

JR 7/1/12 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *57472*

EPB 02/01/12 (12) *PU* 7/1/12

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JS 07/01/12 (12)

Job Completion



U 07.01.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order: 30075	
Description: Saddle, Fwd Inboard		Part Number: D2572	
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.750	1.750	1.749	1.748		
C	3.495	3.505		3.500	3.499	3.501	3.500		
D	1.745	1.755		1.750	1.750	1.749	1.748		
E	7.990	8.010		7.999	8.002	8.002	8.001		
F	0.490	0.510		0.501	0.493	0.496	0.496		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.378	0.378	0.378	0.378		
I	0.490	0.510		0.494	0.496	0.495	0.494		
J	1.174	1.184		1.174	1.174	1.174	1.176		
K	0.558	0.578		0.561	0.566	0.565	0.560		
L	1.174	1.184		1.174	1.174	1.174	1.176		
M	1.490	1.500		1.492	1.493	1.494	1.492		
N	2.495	2.505		2.498	2.497	2.499	2.499		
O	3.869	3.879		3.870	3.871	3.870	3.871		
P	0.115	0.135		0.126	0.124	0.124	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.248	0.248	0.249		
S	0.115	0.135		0.118	0.120	0.124	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.237	0.236	0.234	0.236		
W	0.115	0.135		0.125	0.120	0.126	0.126		
X	0.307	0.312		0.311	0.311	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.368	0.370	0.366	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.623	0.623	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.246	0.250	0.244		
AE	1.375	1.395		1.387	1.390	1.386	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.266	0.260	0.260		
AH	0.240	0.260		0.249	0.245	0.244	0.245		
AI	2.000	2.020							
AJ	0.023	0.043		0.030	0.030	0.036	0.030		
Accept/Reject									

Measured by: <i>CP</i>	Audited by: <i>J.L.</i>
Date: 07/01/03	Date: 07/01/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 30075	
Description: Saddle, Fwd Inboard		Part Number: D2572	
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.439	.439	.439	.439		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		.503	.503	.503	.503		
G	0.257	0.262	DT8683	.260	.260	.260	.260		
H	0.375	0.380	DT8684	.375	.375	.375	.375		
I	0.490	0.510		.503	.503	.503	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.125	.125	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.963	2.963	2.963	2.963		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.230	.230	.230	.230		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.761	.761	.761	.761		
Z	0.352	0.372		.370	.370	.370	.370		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.386	1.386	1.386	1.386		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.010	2.010	2.010	2.010		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	TSG / EP
Date:	07.01.08

Audited by:	J.F.
Date:	07/01/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 30095	
Description: Saddle, Fwd Inboard		Part Number: D2572	
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.749	1.749	1.749	1.750		
C	3.495	3.505		3.499	3.501	3.501	3.499		
D	1.745	1.755		1.749	1.749	1.749	1.750		
E	7.990	8.010		8.004	8.001	8.001	8.003		
F	0.490	0.510		0.491	0.496	0.499	0.495		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.378	0.378	0.378	0.378		
I	0.490	0.510		0.498	0.495	0.494	0.499		
J	1.174	1.184		1.177	1.175	1.177	1.177		
K	0.558	0.578		0.563	0.561	0.568	0.567		
L	1.174	1.184		1.177	1.175	1.177	1.177		
M	1.490	1.500		1.493	1.494	1.496	1.491		
N	2.495	2.505		2.500	2.498	2.498			
O	3.869	3.879		3.873	3.873	3.873	3.876		
P	0.115	0.135		0.123	0.127	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.248	0.250	0.250	0.251		
S	0.115	0.135		0.116	0.120	0.121	0.111		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.230	0.232	0.230	0.236		
W	0.115	0.135		0.123	0.123	0.123	0.122		
X	0.307	0.312		0.311	0.311	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.366	0.366	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.624	0.624	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.242	0.245	0.246	0.246		
AE	1.375	1.395		1.389	1.387	1.388	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.242	0.242	0.242	0.246		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by: <i>En</i>	Audited by: <i>J.F.</i>
Date: 07/01/09	Date: 07/01/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

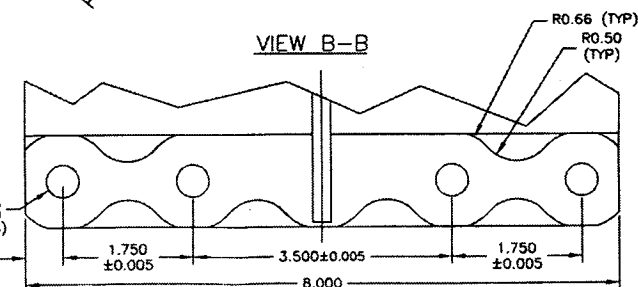
05.12.06

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
 (REF DART SPEC. D6102-003)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
 3 CHAMFER 0.063 x 45° ALL AROUND
 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW B-B



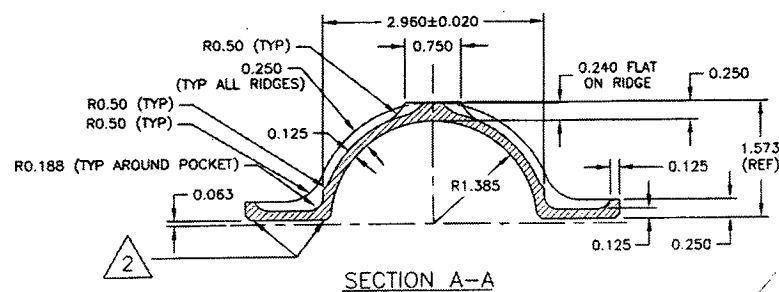
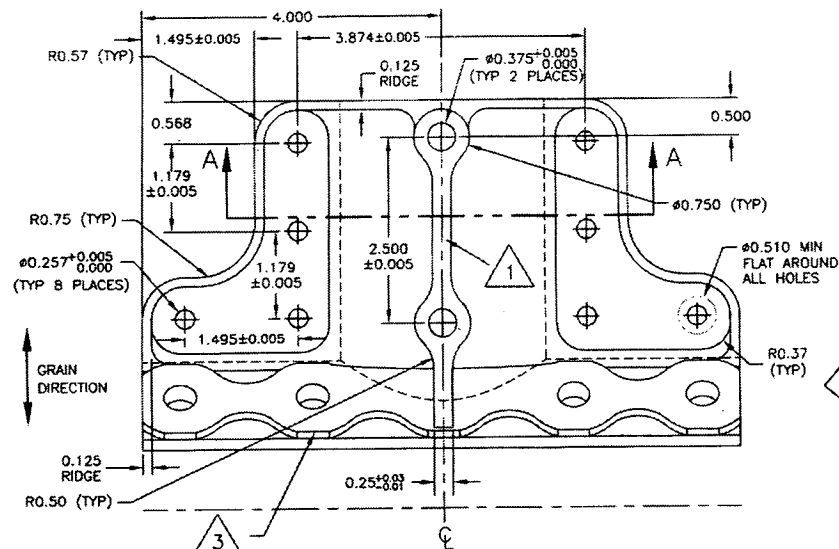
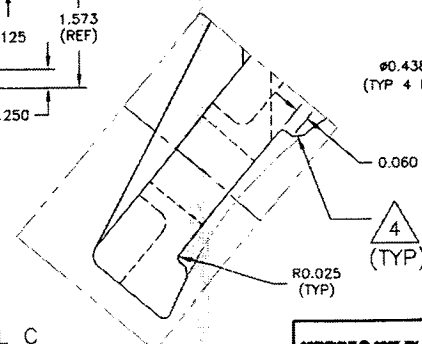
E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD. MISSISSAUGA, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO.	D2572
DATE	05.07.13	TITLE	INNER FWD SADDLE		
				REV. E	SHEET 1 OF 1
				SCALE	2:1

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DETAIL C
 SCALE 2:1



050716/1102
 110 30095